Work Orde November-11-13				*109	111*						Page 1
•	D3864-1			Accept	*N900	040	100	<b>)*</b> s	etup Sta	rt *N	S1*
Revision ID: Item Name:	Bushing								Sto	p *\	S2*
Start Date:	11/11/13	Start Qty: 60.00	*60*		Cust Item I	D:				I W	. 12
Required Date: Reference:	11/25/13	Req'd Qty: 60.00	*60*		Customer:						
Approvals:	Process Pla	n: <u>M</u> L5	Date: /3-//-//	Tooling:	D:	ate:		R	Run Sta	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3864	Rev	A									-
100		Hardinge CNC LATHE S	SMALL	0.00				60	<i>∞</i> ∕		1/12-11-25
*100* Hardinge		Memo		0.00				U			1013116
Hardinge CNC Latho	e Small	1-TURN AS	PER FOLIO FA794 & DW _DWG REV: <b>A</b> 2-		)						
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
*110* QC Quality Control		Мето		0.00				leo	Ø		SS13-11-25
120		QC8- Inspect parts - seco	and check	0.00							•
*120* QC Quality Control		Мето		0.00				60			<u>y 13-11-25</u>

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Worl	c Order un	date only	AEROSPACE
Q, r c.losea.			- Dutc.								-	•		
Work Orde	r:					DISPOSITION				AGAINST [	DEPA	ARTMENT/	PROCESS	
	•				_	Rework		Skid-tube Crosstube					Water Jet	Engineering
Part N	Part No.				Scrap			Machining	Small Fab		Prod. Eng. Coor.		Quality	
						Use-as-is		Therr	moforming	Finishing	_	Rec/Stor	e/Packaging	Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite			Supplier	
Root					Desci	ription of work order update		nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design														
Doc/Data														
Equip/Tooling	_										İ			
Handling/Pre	_			·										i
Material	4													
Operator	_	:												
Offset/Setup	_						1					:		
Process				<u> </u>					ļ		1			:
Supplier														
Training							1							
Transport														
Unapproved					<u> </u>		<u></u>				Щ.			1
						<del></del>	FAI	ULT CA	TEGORY					
Landi		1				General		1 /-		г	٦,		. г	<del></del>
	-	Bending			<u> </u>	Bend	<u> </u>	1	Program	ŀ	_	utside Dim	<del> </del>	Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	-	Grain		ļ.	_	ver/Under	<u> </u>	Set-up
		Cracks	.   . / D :   -	/\ \ / = =	$\vdash$	Broken/Damage/Defect	<u> </u>	Hardwa			_	art Incorred	<b>}</b>	Temperature/Cure
	Crimp/Kink/Ripple/Wave			$\vdash$	Burrs	⊢	1 '	ion Incomplete/Ur	·	_	art Lost/Mi	ssing	Weld	
	-	Cuffs			-	Countarink	$\vdash$	1	tions Incomplete/l	Inclear		art Moved	<u></u>	Wrong Stock Pulled
	_	Crushing Heat Trea	.+		$\vdash$	Countersink Cut Too Short	$\vdash$	• •	gned/off center	}		ositioned V		Othor
		Inspection		Tubo	$\vdash$	Drawing	$\vdash$	Mislabo Misrea		L		ower Loss/	ourge [	Other
	_	Marks/Ch	-	iune	$\vdash$	Drill Holes	$\vdash$	Off-set			_			
		Turning S			-	Finish	$\vdash$	4	Calibration		_			
		Wave/Tw			-	Fit/Function	$\vdash$	-	Sequence					
j		wave/ IW	ISCHII LUL	<b>,</b> c		prigrament	1	Jour of	Jequence					

November-11-13 1:53:22 PM Item ID: D3864-1

Item Name: Bushing

**Start Date:** 

11/11/13 Required Date: 11/25/13

Req'd Qty: 60.00

**Start Qty:** 60.00

\*60\* \*60\*

**Cust Item ID:** 

**Customer:** 

Reference:

**Revision ID:** 

Approvals:

Process Plan:

QC:

Date:

Date: Tooling:

Accept

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date:

\*N900040100\*

Run Start

Reject

Setup Start

Stop

Stop

Sequence ID/ Work Center ID

\*130\*

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location. Stock

Memo

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Qty Number

Reject

DAS

Insp.

Stamp

13-11-25

140

130

\*140\*

QC Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

DQA:			Date:										
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							Wo	rk Order up	date only	
Work Orde	or.					DISPOSITION			AGAINST	PROCESS			
Work Orac	•					Rework			Skid-tube Crosstube		ı	Engineering	
Part N	lo.					Scrap			Machining Small Fab	Н	Pro	Water Jet d. Eng. Coor.	Quality
	•				_	Use-as-is			moforming Finishing			e/Packaging	Other
NCR N	۱o. ِ			<u>-</u>		Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling			:										
Handling/Pre													
Material													
Operator									•				
Offset/Setup													
Process													
Supplier 							1						
Training											;		
Transport Unapproved													
Unapproved			i	<u> </u>	!		FΔI	UIT CA	TEGORY			L	
Landi	nø (	Gear				General							
	_	Bending				Bend		] Folio/I	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	•		Over/Under		Set-up
	Г	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci 🗀	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set				· · · · · · · · · · · · · · · · · · ·	
		Turning S	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube			Fit/Function		Out of	Sequence						

**Picklist Print** 

November-11-13 1:53:26 PM

Parent Item Name: Bushing

Work Order ID: 109111

Parent Item:

D3864-1

\*109111\* \*D3864-1\*

**Start Date:** 11/11/13

Required Date: 11/25/13

Page 1

**Start Qty:** 60.00

Required Qty: 60.00

Comments:

IPP Rev:A

New Issue JLM 08-12-06 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	74.4880	0.101	7		01	
*M303R1	იიი*								**	7.800	oʻ	M1	3-11-25

303 Round Bar 1.00

**Location** Loc Code Loc Qty MAT028 74.48801579 121070 1.5789E-05 7.800' m126618 74.488

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		·	Date:							W	ork Order up	date only		
Work Orde	or.					DISPOSITION			AGAINST					
Work Orac					—	Rework	1	Skid-tube Crosstube			Water Jet			Engineering
Part N	lo.					Scrap	1		Machining Small Fab	_	Prod. Eng. Coor.			Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging		Other
NCR 1	No.					Suspected Unapproved	]		Large Fab Composite	:	]	Supplier		
Root		-		1	Desci	ription of work order update	Ī	nitial	Action		Sign &	-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling									<u> </u>					
Handling/Pre									!					
Material	Ш						l							
Operator			1											
Offset/Setup							İ							
Process														<u> </u>
Supplier	$\vdash$		[									:		
Training	Н													
Transport Unapproved	H													
опаррточеа			1	<u> </u>	L		FA	ULT CA	TEGORY		·	l		<u> </u>
Landi	ng (	Gear				General								
		Bending				Bend		Folio/F	Program	Г	Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/M	issing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned \	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge		Other
Inspection Strip in Tube				Drawing		Misrea	d							
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Wave/Twist in Tube			Fit/Function		Out of	Sequence							



DART AEROSPACE LTD	Work Order:	109///
Description: Bushing	Part Number:	D3864-1
Inspection Dwg: D3864 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	i Oloranoo	Dimension	Accep.	,	Inspection	
Ø0.625	+/-0.010	.6235 .471	V		5102	Mic
Ø0.472	+/-0.010	e471	<b>V</b>		14	
Ø0.386	+0.006/-0.001	.386	<b>/</b>		SL08	Ven
0.572	+/-0.010	.572	/		į (	,
0.118	+/-0.010	1.188	/		((	
1.190	+/-0.010				· · ·	
Ø0.787	10:010 0:004	.785			5102	Mic
R0.005 to R0.010	N/A	.008	/			
, , , , , , , , , , , , , , , , , , ,						
,			ļ			
		<u> </u>				
	1///					

	1)//			
Measured by:	Sf	Audited by:	Preliminary Approval:	
Date:	13-11-24	Date: 13-11-25	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.05.20	New Issue	KJ , A	
В	10.12.21	Tolerances revised	KJ KJ	- 10

